



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

650.7610

Job Sheet 211622



Part No: 650.7610

Job Qty: 3 pcs

Part Name: Trigger



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 7/24/20

Type: SOLD

Description:

Note: DWG 650.7600 REV.PA1 IPP REV.A NEW ISSUE JFS 20/07/03 VERIFIED BY:DD

Ship Via:

139 Value

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS	Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time		
100	HAAS 5 Axis	3 pcs	7/24/20	7/24/20	0.75	2.25	HAAS - 1 - 5		33	20/08/20
							HAAS - 2 - 5		9-89	
110	QC 2	3 pcs	7/24/20	7/24/20	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32		DAS	
							QC 2 - 33		33	20/08/20
							QC 2 - 35		9-89	
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S295356



Part: 650.7610

Job No: 211622

Serial No/Batch: S295356

Revision: REV. PA1

Inspector:

Exp Date:

Instructions:

Date: 08/20/20

Plex 7/22/20 9:18 AM Dart.Renwick.Jennife

5000/ PEI

120 QC 8	3 pcs	7/24/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
160 Packaging 3-1 - Stock - B4B	3 pcs	7/24/20	0.00 0.00	QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	

9/20/08/20

DAS
82
9-89

AUG 20 2020

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	DAS
170 QC 21 - SA	3 pcs	7/24/20	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-30
				QC 21 - SA - 9	AUG 21 2020

Part Op **100** - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio FD 11/4 FOLIO REV:
 Descriptions: A2 DWG. REV: PA1 2-Debur
110 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
160 - Identify as per dwg & Stock ****CRITICAL PART - EXTREME CARE MUST BE TAKEN**** ****MUST ENSURE THE COMPONENTS ARE NEVER DAMAGED****
170 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R0.625	303 Round Bar 0.625"	.5000 ft (.16667 ea)	100-HAAS 5 Axis	<u>5250214</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 5 Axis	M303R0.625	1	11	0

Part Specifications
Specifications could not be found.

Plex 7/22/20 9:18 AM Dart.Renwick.Jennifer

7

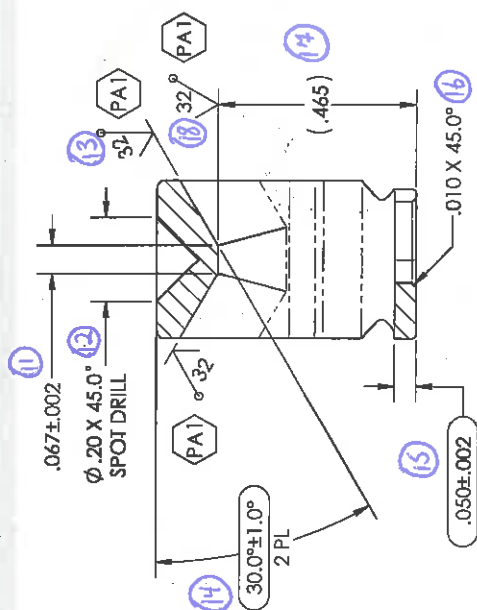
40

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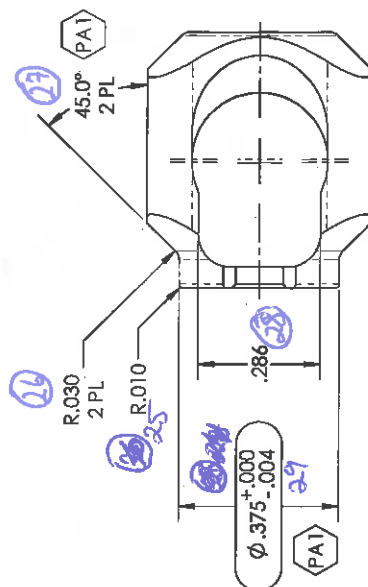
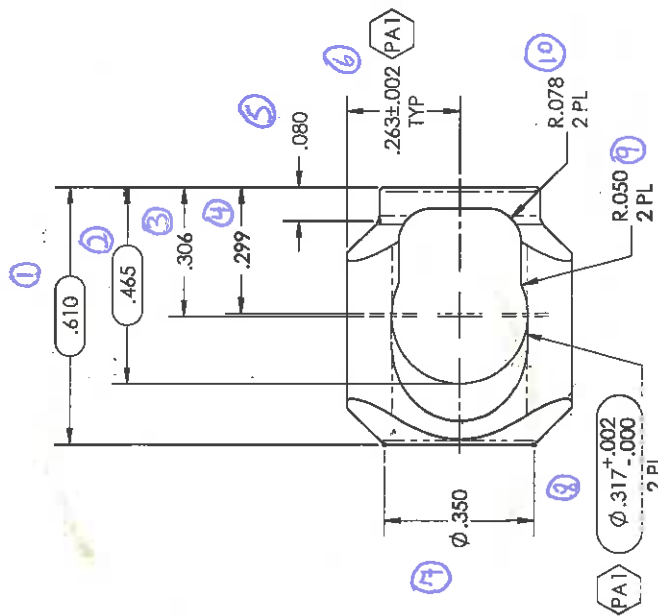
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	04-25-2014	P. BRAVO
A	INCORPORATED ECN 064302	06-15-2017	P. BRAVO

1 MATERIAL: 303 SS IAW AMS-5640 **30**

2. DEBURR AND BREAK ALL SHARP EDGES
3. IDENTIFY IAW MPP-120
4. FINISH 125/MAXIMUM UNLESS OTHERWISE SPECIFIED



SECTION A-A
SCALE 3.5:1



PROTOTYPE REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
A-1		ADDED SURFACE ROUGHNESS VALUE		
A6-1		ADDED SURFACE ROUGHNESS VALUE		
C-1		ADDED .243 ± .002 DIMENSION		
C-1	PA1	DIMENSION WAS .535 ± .002 IS .526 ± .002	06/01/2020	T. CROSS
C-1		ADDED SURFACE ROUGHNESS VALUE		
C-1		DIMENSION WAS .535 ± .002 IS .526 ± .002		
D-1		ADDED .43 ± .02 P/D DIMENSION		
D-1		ADDED .3 P/D TO DIMENSION		

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 211622

[illegible]

TRIGGER

NO. 650.7600

2

DART AEROSPACE LTD		Work Order: 211622
Description: TR166FR		Part Number: 650.7610
Inspection Dwg: 650.7600 Rev: PA1		Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
①	0.610	± 0.005	0.609	✓		MJP-04	vern
②	0.465	± 0.005	0.466	✓			
③	0.306	± 0.005	0.306				
④	0.299	± 0.005	0.299				
⑤	0.080	± 0.005	0.085	✓			
⑥	0.263	± 0.002	0.2625	✓			
⑦	0.350	± 0.005	0.345	✓			
⑧	0.317	± 0.002	0.3185	✓			
⑨	R 0.050	± 0.005	0.050	✓			
⑩	R 0.078	± 0.005	0.078	✓			
⑪	0.067	± 0.002	0.068	✓			
⑫	0.20 x 45°	± 0.010 ± 2°	0.202 x 45°	✓			
⑬	32°	±	14°	✓			
⑭	30°	± 1.0°	30°	✓			
⑮	0.050	± 0.002	0.050	✓			
⑯	0.010 x 45°	± 0.005 ± 2°	0.008 x 45°	✓			
⑰	(0.465)	± 0.005	0.466	✓			
⑱	32°	±	15.5°	✓			
⑲	32°	±	15.5°	✓			
⑳	R 0.105	± 0.005	0.105	✓			
㉑	0.110	± 0.002	0.110	✓			
㉒	0.170 x 45°	± 0.005 ± 2°	0.170 x 45°	✓			
㉓	0.375	± 0.002	0.375	✓			
㉔	0.526	± 0.002	0.526	✓			
㉕	R 0.010	± 0.005	0.010	✓			
㉖	R 0.030	± 0.005	0.030	✓			
㉗	45°	± 2°	45°	✓			
㉘	0.286	± 0.005					
㉙	375	± 0.005					
㉚							
㉛	303 SS		303 SS				
	AMS 5640		AMS 5640				MILL TEST ATTACHION H/T 462762

Measured by: 33	Checked by: [Signature]	QC Inspector:
Date: 20/08/20	Date: 20/08/20	Date:

Engineering Approval: (If necessary)	Date:
---	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QS1042) ☐																													
Date :		Sequence #:		QTY Affected :		Disposition																															
Description Work Order Deviation																																					
Completed By																																					
Lead hand / Supervisor																																					
QC / QA Coordinator																																					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>								Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																		
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																																		
Mislabeled	Fit/Function	Off-set/Set-up																																			
Other/Details:																																					

good for both 30° angles surface

Mitutoyo Surtest SJ-400

DATE 2000-01-01 TIME 10:32:20

STAND JIS2001

PROFILE FILTER GAUSS

EVA-L 0.05in

N 0.01in

λc 100μin

TILT-COMP. ALL

CURVE-CMP. OFF

M-SPEED 0.02in/s

R-SPEED 0.04in/s

AUTO-RTN ON

RANGE 32000μin

DRIVE ±ESC

STYLUS STAND ON

PRE/POST ON

R-PROFILE

EVA-L 0.05in

λc 0.01inX5

Ver. 100.000μin/in

Hor. 0.010in/in

14.6μin

60μin

17.2μin

Ra

Rz

Rq

100

10K

0.05in

0.01inX5

0.01in

0.01in

0.01in

0.01in

0.01in

0.01in

0.01in

0.01in

0.01in

0.01in

0.01in

0.01in

Shipping Order 22/01/2020

Order Reference : 149625
: pohb045541
: PICK UP / PICK UP

Ship To

Same

Tel: 1 613 632-3336

METAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
LONGUEUIL, QUEBEC
JAN 1LT
Tel: 450 641-3330

Customer: 6323336

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Item No.	Description	Qty	Qty Delivered	B/O Qty
----------	-------------	-----	---------------	---------

***** FACTURER E-MAIL ***** SUPER IMPORTANT SUR
LE PACKING SLIP INSCRIRE LES HEAT N

MR3441H	4140 HTSR ROU 750 DIA	22	22	2
---------	-----------------------	----	----	---

MR11841H	4140 HTSR ROU 1 125 DIA ht75070620 1 x 22"	23 42	23 42	5
----------	--	-------	-------	---

DT12083	MS TUB .500" X .083" WALL DOM ht75072955 1 x 20" x 1/2"	81	81	2
---------	---	----	----	---

SR503	303 ROU .625 DIA ht mm12108407 4 x 20" x 1/2"	25	25	5
-------	---	----	----	---

SR13	303 ROU 1 000 DIA ht 462762 2 x 12" x 1/2"	36	36	8
------	--	----	----	---

MP124130N	4130 NORM PLATE 500 THICK AMS 0345 ht 432071 3 x 12" x 1/2"	11 58	11 58	4
-----------	---	-------	-------	---

TP12A2	A-2 PLATE TFA 1/2" THICK ht 1961550 40 x 3" x 14"	102	102	5
--------	---	-----	-----	---

4 x 1.25" - 0.0656" x 1.14" x 1/2"
ht 9919020379B-48-1

live
IP

Merchandise Received:

Shipping :
Package No :

Ref. :

ACEROS INOXIDABLES
OIAIRA

180 3:00M / 551 1974728
 180 3:00M / 551 1974728
 180 3:00M / 551 1974728

Letras de LOUI (VIZ. AYA) Espadas
P.O. Box 1, 323/48080 Bismarck
Tel. 39-(4) 4 71 13 00
Fax. 34-(4) 4 53 16 36

LINE 4
M303R0.625
N/T 4622762
SD50214

SPECIFICATION CONTROL DRAWING

DAS
82
0-93

PURCHASE MATERIAL: AISI 303 SS ROUND BAR
(NOTE: AISI 304/316 NOT ACCEPTABLE)

SPECIFICATION:
PART NUMBER:

ASTM A582
M303R0.625 DIA.

WHERE "0.000" = DIAMETER IN INCHES
EG. 0.75" ROUND BAR = M303R0.750

RELEASED
2010-02-02
N/C

0	REFORMAT DWG. AND SPECS (2N D8-1)	CP	10.01.05
A	NEW ISSUE	DS	01.12.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.05		
DART AEROSPACE LTD		REV. B	
HAMMERSLEY, ONTARIO, CANADA		SHEET 1 OF 1	
DRAWING NO. M303R		SCALE	
TITLE 303 ROUND BAR		NTS	
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MATERIAL RECEIPT INSPECTION FORM

Line 4

MATERIAL: M3032.0.625
DATE: JAN 24 2020

PO / BATCH NO.: 1041804554 / 5250214

MATERIAL CERT REC'D: YES
QUANTITY RECEIVED: 25 ft
QUANTITY INSPECTED: 25 ft
QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.625
THICKNESS RECEIVED: 0.625
SHEET SIZE ORDERED: 1
SHEET SIZE RECEIVED: 1

DESCRIPTION	NCR (Check Y/N)	COMMENTS
-------------	-----------------	----------

SURFACE DAMAGE	Y	625 2004/11/24
CORRECT FINISH	Y	
CORROSION	Y	
CORRECT GRAIN DIRECTION	Y	
CORRECT MATERIAL PER M-DRAWING	Y	
CORRECT THICKNESS	Y	ASTM A582
PHOTO REQUIRED	Y	
CORRECT REF # TO LINK CERT	Y	462462
CORRECT MATERIAL IDENTIFICATION	Y	
CORRECT M# ON THE MATERIAL	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK.				
RECORD RESULTS BELOW				
HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL				
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

Testers located in the Quality Office

QC 18 INSPECTION
ENGINEERING SIGNOFF (if required)

INSPECTED BY: DAS
DATE: JAN 24 2020
SIGNED OFF BY: 9-89

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

H:\FORMS\Quality Assurance\approved QAMRIF Material Receipt Inspection Form revD